

# Work Order ID 72278

Wednesday, July 20, 2011 3:51:19 PM



Page 1

Item ID:	D2512	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Lid 205/350					
Start Date:	7/20/2011	Start Qty:	2.00	Cust Item ID:		
Required Date:	7/29/2011	Req'd Qty:	2.00	Customer:		

## Reference:

Approvals:	Process Plan:	Date:	11-07-20	Tooling:	Date:
	QC:	Date:		SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2512	Rev E

100 Weld per dwg A/R S.S. rod Batch: M114649 0.00  
Large Fab

Large Fab Memo 0.00

- 1-Cut 3/4" x 3/4" square tubing as per Dwg D2512
- 2-Cut (4) D2236 From D3166-3
- 3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
- 4-Weld as per Dwg D2512 using Welding Jig DT 9436
- Deburr as required
- \*\*\*INSTALL D2012-117 CLEVIS ONLY ON D130-701-041\*\*\*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC Memo 0.00  
Quality Control

11.08.22  
PMB 11/08/22

11.08.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Wednesday, July 20, 2011 3:51:19 PM

Page 2

**Accept**

Revision ID:

**Item Name:** Basket Lid 205/350

**Start Date:** 7/20/2011      **Start Qty:** 2.00

**Required Date:** 7/29/2011      **Req'd Qty:** 2.00

**Reference:**

**Cust Item ID:**

**Customer:**

**Setup Start**

**Stop**

Run Start

**Stop**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

**Tool ID**

Tool #

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

120

QC6- Inspect dimensions to drawing

0.00

QC

## Memo

0.00

## Quality Control

125

Pressure Wash per QSI005 4.3

0.00

HandFinish

## Memo

0.00

## Hand Finishing

8 10 21 23

(7)

~~IX Ø m- / 11/08/23~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date:	7/29/2011	Req'd Qty: 2.00		Customer:		
Reference:						

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	QC:	Date:	SPC (Y/N):	Date:

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat		0.00							
Powder Coating	Memo								
	1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat								
	1ST COAT:								
	START TIME: 1:00								
	OVEN TEMPERATURE: 400 OF								
	FINISH TIME: 1:30								
	2ND COAT:								
	START TIME:								
	OVEN TEMPERATURE:								
	FINISH TIME:								

*Handwritten signature: H J M-6/11/08/23*

140		0.00							
HandFinish		0.00							
Hand Finishing	Memo								
	Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4								
	Batch: 118513								

*Handwritten signature: BR 11-8-24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID 72278**

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Item ID: D2512

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid 205/350

Start Date: 7/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00

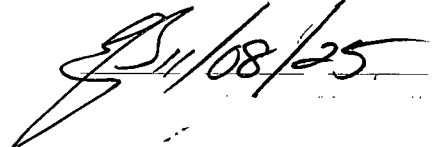


QC

Memo

0.00

Quality Control

 11/08/25 @

160

Identify as per dwg & Stock Location: *G-A* 0.00

Packaging

Memo

0.00

Packaging

*w/o 72279* 11/08/25 @

170

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

*11/8/25**CH 11/08/25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Wednesday, July 20, 2011 3:51:28 PM

Page 1

Work Order ID: 72278



Parent Item: D2512



Parent Item Name: Basket Lid 205/350

Start Date: 7/20/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF  
 IPP Rev:N06.04.05 Added level21 EC  
 IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM  
 VERIFIED BY:DD  
 IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC  
 IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified  
 by:EC IPP Rev:R 10.06.29  
 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-117

Manufactured

No

100

Each

39.0000

2

4



Clevis

Location

Loc Qty

Loc Code

WA

31

69890

31

WA005

8

55729

8

\*\*\* ONLY APPLICABLE ON D130-701-041-IF  
 NOT USED, PLEASE MARK N/A \*\*\*

D2232-1

Manufactured

No

100

Each

16.0000

2



Basket Hinge

Location

Loc Qty

Loc Code

WA

16

70842

16

② Rpl

PMB

11/08/18

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 2

Work Order ID: 72278

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 7/20/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

D2327-1 Manufactured No

100 Each

29.0000

2



Spacer Bushing

Location

Loc Qty

Loc Code

WA

20

69728

20

WA005

9

64899

9

D2506

Manufactured No

100 Each

9.0000

1



Label Plate

Location

Loc Qty

Loc Code

WA

9

69262

1

71087

8

D2581

Manufactured No

100 Each

67.0000

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

67

69258

28

69739

2

70766

37

2 1/2 Pl

PMB

11/08/17

2 1/2 Pl

PMB

11/08/18

1 1/2 Pl

PMB

11/08/17

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

Work Order ID: 72278

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 7/20/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

D3166-3

Manufactured No

100 Each

9.0201

1



Basket Hoop

100  
PMB

## Location

## Loc Qty

## Loc Code

WA

8

70189

8

WA007

1.02010527

64928

0.02010527

68442

1

M304EX0.75-16F

Purchased

No

100

sf

727.0924

18



Expanded Metal Flat SS

~~37.89474~~ 18.94737  
PMB 11/08/18 PL

## Location

## Loc Qty

## Loc Code

MAT

11.5607

117708

11.5607

WA

715.5317

115012

95

117197

102.9036

117455

16.0341

117896

82.9546

118153

98.6394

118248

320

M118450

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Wednesday, July 20, 2011 3:51:29 PM

Page 4

Work Order ID: 72278

Parent Item: D2512

Parent Item Name: Basket Lid 205/350



Start Date: 7/20/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

M304TS0.750W.065

Purchased

No

100 f

626.3913

43.5804

~~91.74821~~

45.8741 RPL



PMB 11/08/17

304 SQ Tube .75x.75x.065W

Location	Loc Qty	Loc Code
MAT018	91.83716	
117598	14.13846	
117636	77.6987	
WA	491.57	
118181	491.57	
WA007	42.9840906	
116267	36.391372	
116763	6.5927186	


~~91.74821~~ 45.8741

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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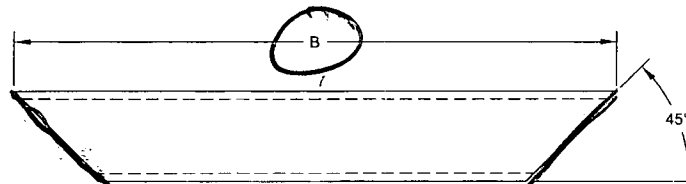
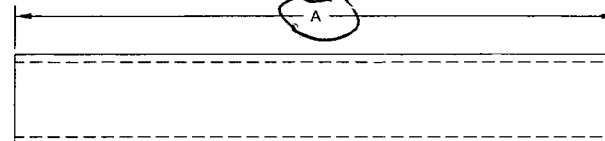
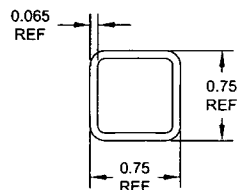
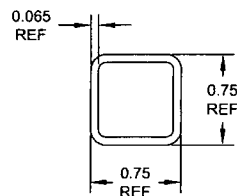
# PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2		25.50	RIB
D2512-3	2		95.30	RIB
D2512-5	6	30.84		RIB
D2512-7	3	30.63		RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 72278

PLN-0720

RELEASED  
08-08-21/17



E

## D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT BE REPRODUCED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

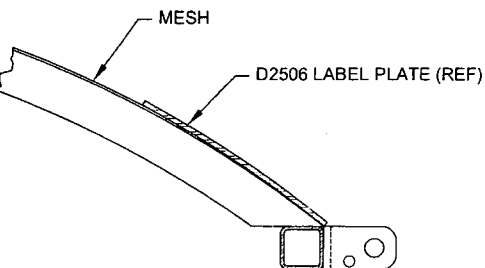
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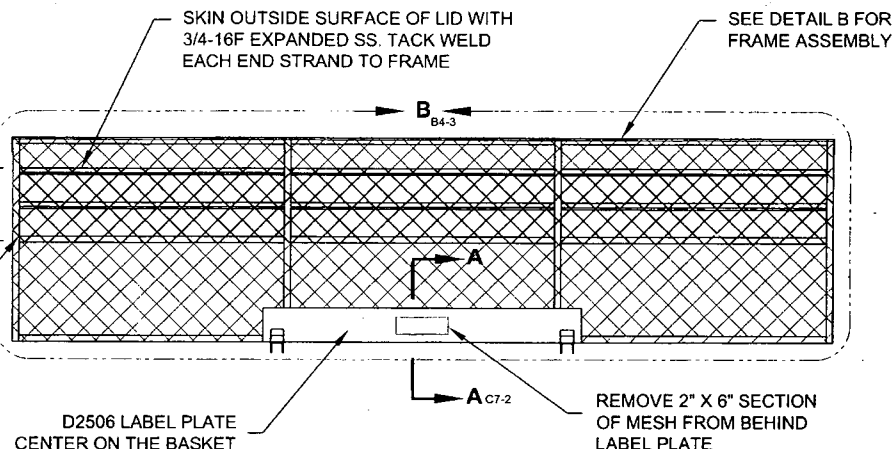
NOTE: Date & initial all entries



**SECTION A-A<sub>B3-2</sub>**  
(ROTATED 90° CCW)

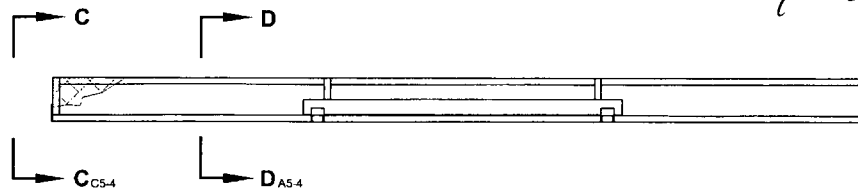
FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED



**D2512 BASKET LID ASSEMBLY NOTES:**

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE  
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004



12278

**RELEASED**  
03.05.21/17

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

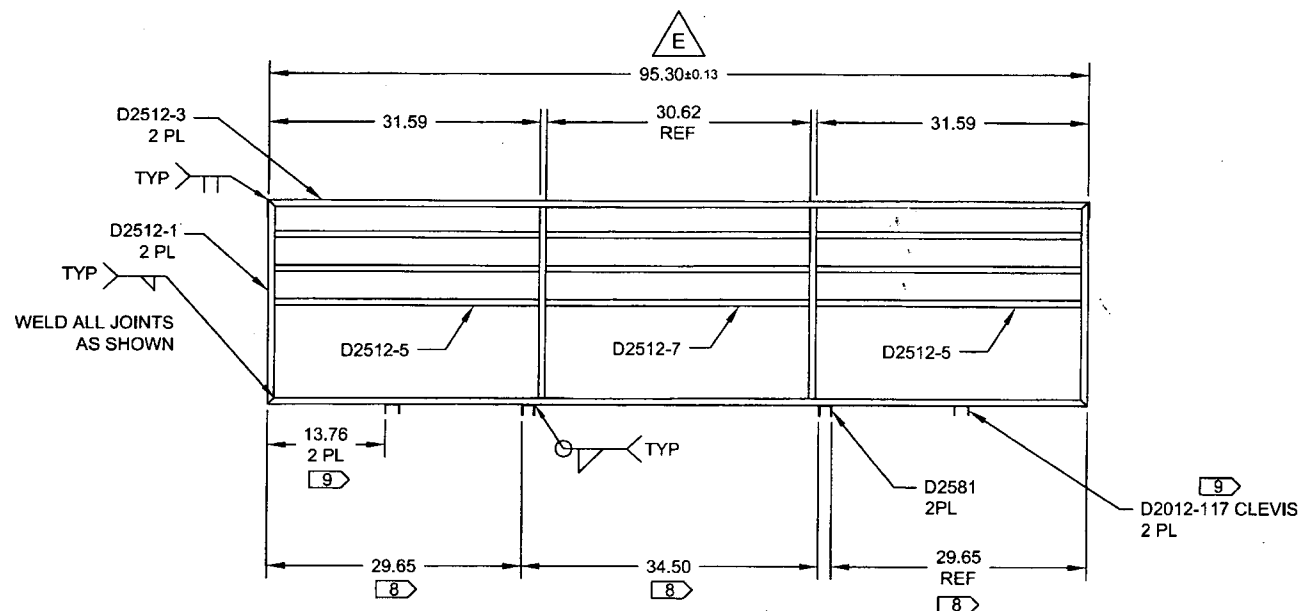
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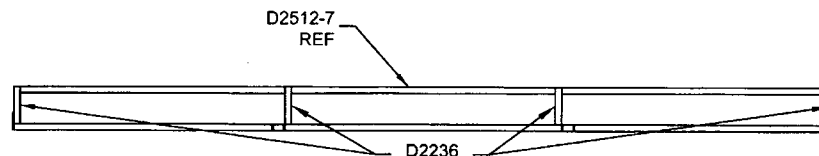
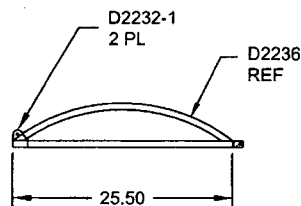
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**DETAIL B** C3-2  
FRAMEWORK ONLY SHOWN FOR CLARITY



**NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
08-06-21-1980

172275

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

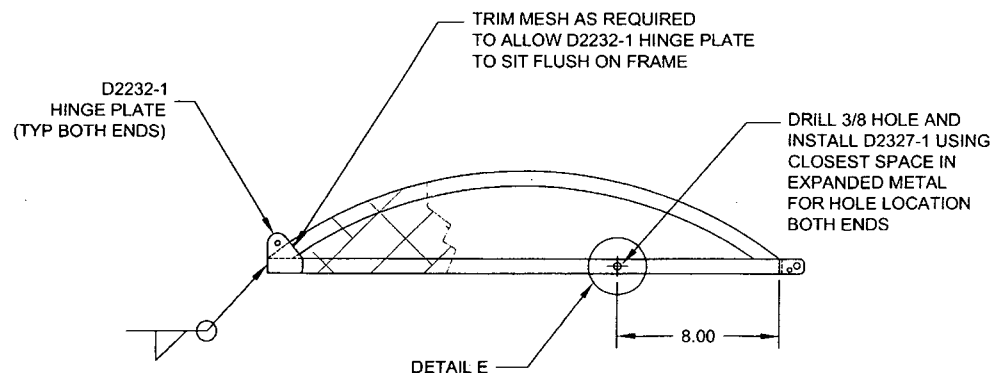
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

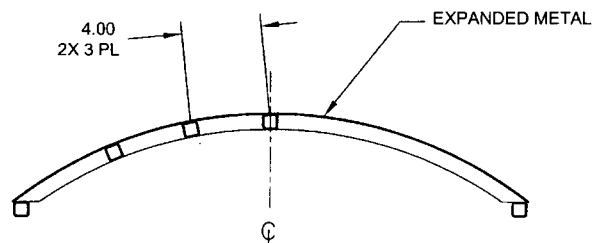
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

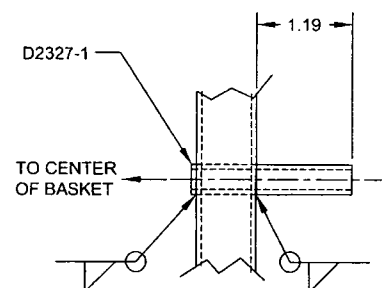
8 7 6 5 4 3 2 1



**VIEW C-C SIMILAR BOTH END RIBS** A5-2



**SECTION D-D SAME BOTH CENTER RIBS** A4-2



**DETAIL E** C6-4

72225

**RELEASED**  
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DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries